

SPLIT

Date: Monday, 1/8/2007 10:42:13 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 30137 - 1	
Estimate Number : 11483	
P.O. Number : N/A	Part Number : D2091
This Issue : 1/8/2007 S.O. No. : N/A	Drawing Number : D2091REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 28120	Material : N/A
Written By : <u> </u>	Due Date : 1/30/2007
Checked & Approved By : <u> </u>	Qty: <u>19</u> Um: Each
Comment : Est: C 9907.18 Re-format DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2000043	Jet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Jet

Pick:

Qty	Part Number	Description
1	D2000-043	Jet

Batch

B28128 (19)

07/03/07

(19)

2.0	D2094	Aspirators
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Aspirator

Pick:

Qty	Part Number	Description
1	D2094	Aspirator Body

Batch

B30153

SP 07/02/05

(19)

3.0	D2095	Aspirator
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Aspirator

Pick:

Qty	Part Number	Description
1	D2095	Aspirator Core

Batch

B30154

SP 07/02/05

(19)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FAB RESOURCE 1

Weld D2000-043 Jet to D2094 Aspirator Body as per Dwg D2091 using Jig DT8294

07/03/07 (19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:42:13 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30137

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-03-06 (19)

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 3262

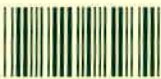
C207103108 (19)

Black Anodize weldment from step 3 and Dwg D2095

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

07-03-16 (19)

8.0

A1449

Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Grommet

76

Pick:

Qty Part Number Description Batch

4 A1449 Grommet

M1487

FF 07-03-20

19

9.0

A1622

Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Grommet

76

Pick:

Qty Part Number Description Batch

4 A1622 Grommet

M1487

FF 07-03-20

19

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install grommets as per Dwg D2091

FF 07-03-20

19

11.0

QC5

INSPECT WORK TO CURRENT STEP




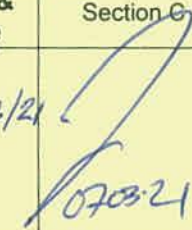

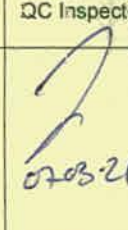
Comment: INSPECT WORK TO CURRENT STEP

07-03-21

(P10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0703-21	10.0	7 parts need 1 grommet a piece changed. based installation due to Flare being in the hole	 051042	Re-work 7 parts.	FF 07/03/21	 0703-21	 051042	 0703-21

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30137

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 2/3/21 (19)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(19)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/22

Job Completion



u 07-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DZ092 SHOWN

A1622
A1449

DZ093 ON DZ090 (45°)
DZ092 ON DZ089 (45°)
DZ094 ON DZ091 (90°)

DZ000-043

AS SHOWN ON DZ092
& DZ093.

ROTATED 45° ON
DZ094

RELEASED
99.01.15

DZ096 ON DZ090

DZ095 ON DZ089 & DZ091

FINISH:

BLACK ANODIZE AFTER WELDING &
PRIOR TO RIVETING.

NO. 30137
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOULDER
COPY

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 2742 5. HOLES PER AND 10267	1. TOLERANCES - .XX X .030 2. ANGLES - XX X 1/4" 3. PARALLELISM - .0025 4. ECCENTRICITY - .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	RIVET CODE SHALL BE PER NAS 523 BASIC CODE D=DRAWN DASH=NO OF SHEETS C=COUNTERSINK LENGTH DASH NO. W=SPOTWELD BASIC CODES BZ=MS20470AD BB=MS20426AD	PART NO. CONTRACT NO. DRAWN CHECKED ETHES CHECKED CLIENT	ITEM DATE 1972	DESCRIPTION TITLE CODE	MATERIAL DART AERO ACCESSORIES INC. VANCOUVER CANADA	SPEC./VENDOR A
	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL		DART		ASPIRATORS		DZ089/90/91	
	REPORT ALL DISCREPANCIES - DO NOT SCALE		SCALE 1:2		SHT 1 OF 1		A	
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 2742 5. HOLES PER AND 10267		1. TOLERANCES - .XX X .030 2. ANGLES - XX X 1/4" 3. PARALLELISM - .0025 4. ECCENTRICITY - .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		RIVET CODE SHALL BE PER NAS 523 BASIC CODE D=DRAWN DASH=NO OF SHEETS C=COUNTERSINK LENGTH DASH NO. W=SPOTWELD BASIC CODES BZ=MS20470AD BB=MS20426AD		PART NO. CONTRACT NO. DRAWN CHECKED ETHES CHECKED CLIENT	



DZ089/90/91

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

**PACKING
SLIP****53589**

14-Mar-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:****00003262**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	
1	19	19	D2094	B30137 ✓
2	19	19	D2095	B30137 ✓

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

53589

14-Mar-2007

CLIENT / CUSTOMER:**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:**

00003262



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	19	19	D2094	B30137	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2
2	19	19	D2095	B30137	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager ☐ ☐ ☐

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE****53589**

14-Mar-2007


**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:** 00003262**CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PRIX UNITAIRE UNIT PRICE	EXTENSION
1	19	19	D2094	B30137	\$0.00	\$0.00
2	19	19	D2095	B30137	\$0.00	\$0.00
			<i>MINIMUM CHARGE</i>			\$180.00
						
						SUB TOTAL: \$180.00
						TPS/GST: \$10.80
						TVQ/PST: \$0.00
						TOTAL AMOUNT DUE: \$190.80

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE**CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

